

Work Order ID 91225

October-03-12 2:41:48 PM

91225

Page 1

Item ID: D2662-2

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH In 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-10-04 Tooling:

Run Start ***NR1***

QC: MLJ Date: 12-10-04 SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2662	Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.
Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB069 & DWG

DWG REV: E
FOLIO REV: AA

12/11/14 FX
12/11/15

DAJ
02
9

12-11-12

x29

Pto

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

12/11/14 FX
12/11/15

DAJ
02
9

12-11-12

x29

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA dot Date: 12/12/12QA Closed: CK Date: 12/12/12

Work Order: <u>91225</u> Part No. <u>02662-2</u> NCR No. <u>12-2073</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input checked="" type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	<u>12-11-12</u>	<u>100</u>	<u>x1</u>	<u>adjusted ball mill T4</u> <u>wings off set H74 for 4th</u> <u>program P4622 entered</u> <u>-.070 instead of</u> <u>-.007. part is .025"</u> <u>under tolerance</u> <u>operator error</u>	<u>12/11/12</u>	<u>Too thin.</u> <u>SCRAP.</u> <u>no replace</u> <u>9/12/11/12</u> <u>134.05</u>	<u>BT</u> <u>02</u> <u>12-11-12</u>	<u>12/11/12</u>	<u>DAS</u> <u>15</u> <u>12/11/12</u>		

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input checked="" type="checkbox"/> Misread <input checked="" type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

91225

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 03/10/2012 **Start Qty:** 30.00

30

Customer:

Required Date: 05/12/2012 **Req'd Qty:** 30.00

30

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 91225

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91225

Page 3

Item ID: D2662-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, RH In 206

Stop ***NS2***

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

0.00

OVEN TEMPERATURE:

29x

12/11/20

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

29x

11/11/20

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Packaging

Memo

0.00

12/11/21 (29)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 91225

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91225

Page 4

Item ID: D2662-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle, RH In 206

Stop ***NS2***

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/11/22

ME

12-11-21

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																								
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Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
Setup <input type="checkbox"/>																											
Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Picklist Print

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Page 1

Work Order ID: 91225

Parent Item: D2662-2

Parent Item Name: Saddle, RH In 206

91225

D2662-2

Start Date: 03/10/2012

Required Date: 05/12/2012

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	42.0000	1	30			
D6101-001													
Saddle Billet													

91234 x 30

**

25 12-11-11

Location

Loc Qty

Loc Code

MAT040

38

69677

2

76836

1

81923

1

85433

11

87606

11

90152

12

MAT042

4

83309

4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
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Training <input type="checkbox"/>											
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DART AEROSPACE LTD				Work Order: 91225	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-2	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616		3.616	3.616	3.612
B	0.256	0.263		.258		.258	.258	.258
C	0.315	0.322		.316		.316	.316	.316
D	2.495	2.505		2.500		2.500	2.500	2.4985
E	1.674	1.684		1.679		1.679	1.679	1.678
F	0.100	0.140		.119		.125	.125	.124
G	0.210	0.230		.225		.225	.225	.224
H	0.615	0.685		.650		.650	.650	.650
I	2.470	2.510		2.490		2.490	2.490	2.492
J	1.313	1.343		1.335		1.330	1.329	1.329
K	0.178	0.198		.188		.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.141	1.136	1.137	1.138	1.136
N	0.100	0.180		.143		.140	.140	.140
O	0.100	0.140		.110		.119	.116	.111
P	0.240	0.260		.252		.251	.250	.252
Q	0.677	0.697		.687		.685	.685	.685
R	0.540	0.560		.549		.549	.550	.548
S	0.912	0.932		.926		.921	.921	.923
T	0.787	0.807		.792		.797	.797	.796
U	5.990	6.010	6.000	6.000		6.000	5.999	6.000
V	4.995	5.005	5.000	5.000		5.000	5.000	.500
W	0.490	0.510		.500		.504	.505	.504
X	0.312	0.319		.314		.314	.314	.314
Y	0.990	1.010		1.000		1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250		1.250	1.250	1.249
AB	0.490	0.510		.500		.501	.501	.500
AC	3.745	3.755		3.750		3.750	3.750	3.750
AD	0.100	0.140		.134		.130	.130	.132
AE	0.235	0.240		.236		.236	.236	.237
AF	0.510	0.515		.511		.513	.513	.512
AG	0.100	0.120		.103		.111	.111	.112
AH	1.565	1.585		1.581	1.579	1.578	1.577	1.578

Accept/Reject

Measured by: ZT 02 DAS	Date: 12-11-12
Audited by: 14 OR	Date: 12/11/12
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	M

DART AEROSPACE LTD		Work Order:	91225
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	7	8	9	10
A	3.611	3.621		3.611	3.611	3.611	3.611	3.611
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.499	2.498	2.498	2.498	2.496
E	1.674	1.684		1.678	1.678	1.678	1.678	1.678
F	0.100	0.140		.123	.122	.123	.123	.122
G	0.210	0.230		.224	.223	.223	.223	.223
H	0.615	0.685		.650	.650	.650	.650	.650
I	2.470	2.510		2.492	2.492	2.492	2.492	2.492
J	1.313	1.343		1.328	1.328	1.327	1.328	1.328
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.136	1.133	1.1353	1.1361	1.1348
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.111	.111	.111	.112	.113
P	0.240	0.260		.252	.252	.252	.254	.254
Q	0.677	0.697		.684	.685	.685	.684	.684
R	0.540	0.560		.549	.551	.551	.551	.551
S	0.912	0.932		.924	.922	.922	.922	.919
T	0.787	0.807		.797	.797	.797	.797	.799
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.504	.498	.499	.497	.500
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.501	.502	.501	.502
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.135	.130	.131	.133	.132
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.112	.112	.112	.112
AH	1.565	1.585		1.577	1.5727	1.5747	1.5751	1.5739

Accept/Reject

Measured by:	<i>[Signature]</i>	Date:	12/11/13
Audited by:	<i>[Signature]</i>	Date:	12/11/14
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	<i>[Signature]</i>

DART AEROSPACE LTD				Work Order: 91225	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-2	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	3.611	3.621		3.612	3.6125	3.612	3.612	3.612
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.498	2.498	2.497	2.4985	2.497
E	1.674	1.684		1.678	1.679	1.678	1.678	1.678
F	0.100	0.140		.121	.121	.120	.119	.120
G	0.210	0.230		.221	.221	.221	.220	.220
H	0.615	0.685		.650	.650	.650	.650	.650
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.326	1.327	1.3265	1.3255	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.1344	1.1347	1.1338	1.1336	1.133
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.113	.114	.112	.114	.112
P	0.240	0.260		.253	.253	.253	.253	.253
Q	0.677	0.697		.686	.684	.685	.688	.688
R	0.540	0.560		.551	.5495	.5495	.5495	.5495
S	0.912	0.932		.916	.918	.917	.919	.917
T	0.787	0.807		.800	.799	.801	.800	.802
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.495	.496	.493	.494	.496
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.501	.5025	.500	.502	.502
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.132	.133	.132	.134	.133
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.112	.112	.112	.112
AH	1.565	1.585		1.5733	1.5735	1.5728	1.5724	1.572
Accept/Reject								

Measured by: <i>AS</i>	Date: 12/11/13
Audited by: <i>14</i>	Date: 12/11/16
Prototype Approval: <i>8-89</i>	Date: -

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	<i>M</i>

DART AEROSPACE LTD				Work Order: 91225	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-2	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
A	3.611	3.621		3.612	3.613	3.613	3.613	3.613
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.4975	2.500	2.499	2.498	2.498
E	1.674	1.684		1.6795	1.679	1.678	1.678	1.678
F	0.100	0.140		.120	.120	.122	.120	.122
G	0.210	0.230		.219	.220	.221	.221	.220
H	0.615	0.685		.650	.650	.650	.650	.650
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.326	1.326	1.327	1.327	1.329
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.1326	1.1314	1.1392	1.140	1.1336
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.112	.109	.109	.113	.110
P	0.240	0.260		.255	.255	.248	.250	.252
Q	0.677	0.697		.687	.686	.685	.686	.686
R	0.540	0.560		.5495	.5485	.5485	.549	.549
S	0.912	0.932		.917	.919	.918	.918	.916
T	0.787	0.807		.799	.799	.799	.800	.800
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.4945	.4935	.494	.495	.497
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.501	.500	.501	.501	.501
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.135	.132	.131	.134	.132
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.112	.112	.112	.112
AH	1.565	1.585		1.5712	1.570	1.5782	1.5792	1.5726

Accept/Reject

Measured by: <i>AS</i>	Date: 12/11/14
Audited by: <i>14</i>	Date: 12/11/14
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	<i>M</i>

DART AEROSPACE LTD				Work Order: 91225	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-2	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21	22	23	24	25
A	3.611	3.621		3.612	3.612	3.612	3.613	3.613
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.497	2.498	2.498	2.500	2.500
E	1.674	1.684		1.678	1.678	1.679	1.679	1.679
F	0.100	0.140		.121	.121	.120	.121	.121
G	0.210	0.230		.221	.221	.220	.220	.221
H	0.615	0.685		.650	.650	.650	.650	.650
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.327	1.327	1.327	1.327	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.134	1.1332	1.1335	1.134	1.132
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.115	.115	.116	.120	.124
P	0.240	0.260		.253	.253	.254	.256	.256
Q	0.677	0.697		.685	.688	.687	.686	.687
R	0.540	0.560		.550	.549	.550	.551	.551
S	0.912	0.932		.918	.918	.917	.919	.919
T	0.787	0.807		.800	.800	.800	.801	.801
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.493	.495	.496	.496	.496
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.502	.504	.503	.503	.503
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.132	.132	.132	.133	.130
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.112	.112	.112	.112
AH	1.565	1.585		1.573	1.5722	1.5717	1.5726	1.571

Accept/Reject

Measured by:	<i>[Signature]</i> 1 Feb 12/11/15	Date:	12/11/14
Audited by:	<i>[Signature]</i> 14 Jan	Date:	12/11/14
Prototype Approval:	<i>[Signature]</i>	Date:	

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	<i>[Signature]</i>

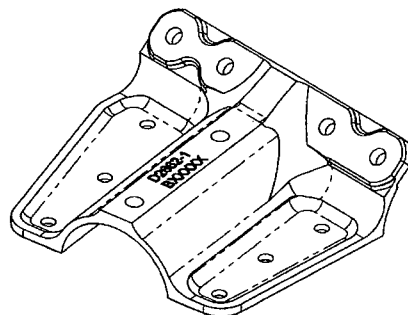
DART AEROSPACE LTD				Work Order: 91225	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-2	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

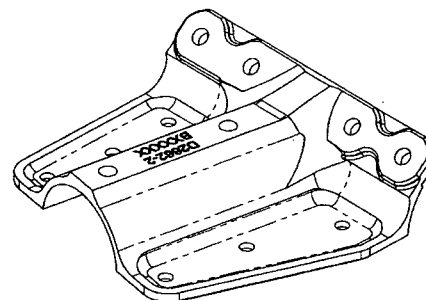
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				26 ±	27 ±	28 ±	29 ±	30 ±
A	3.611	3.621		3.614	3.614	3.614	3.614	3.614
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.121	.123	.122	.124	.122
G	0.210	0.230		.220	.222	.222	.221	.222
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.326	1.328	1.327	1.328	1.327
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.133	1.136	1.136	1.134	1.135
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.122	.122	.125	.127	.127
P	0.240	0.260		.256	.256	.256	.255	.256
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.550	.550	.550	.550	.550
S	0.912	0.932		.919	.919	.919	.919	.919
T	0.787	0.807		.802	.802	.802	.802	.802
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.497	.497	.497	.494	.496
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.503	.503	.504	.504	.504
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.132	.128	.130	.128	.130
AE	0.235	0.240		.237	.237	.237	.237	.237
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.112	.112	.112	.112	.112
AH	1.565	1.585		1.572	1.575	1.576	1.573	1.574
Accept/Reject								

Measured by: FK	Date: 12/11/15
Audited by: [Signature]	Date: 12/11/16
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	[Signature]



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

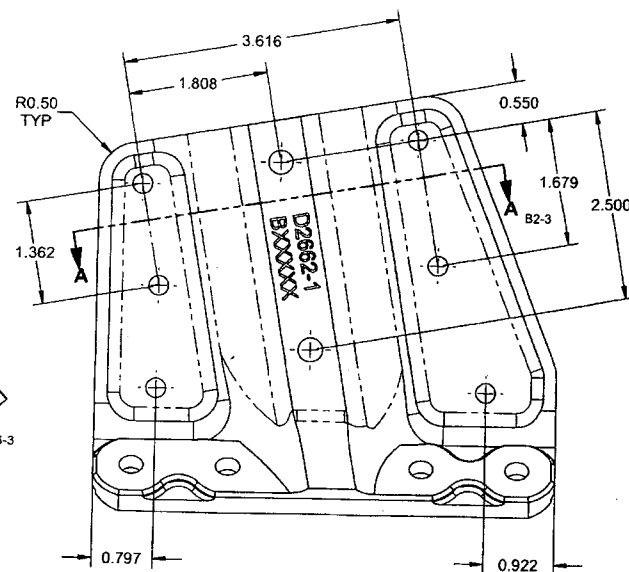
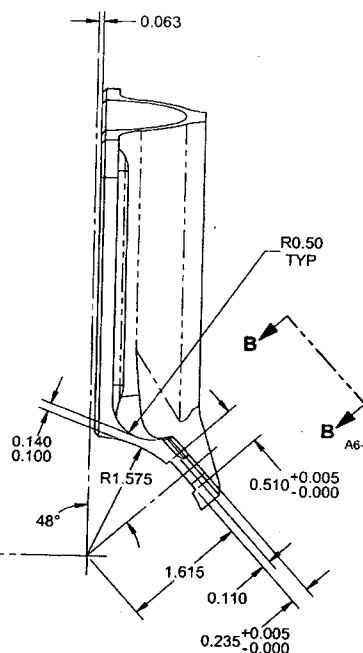
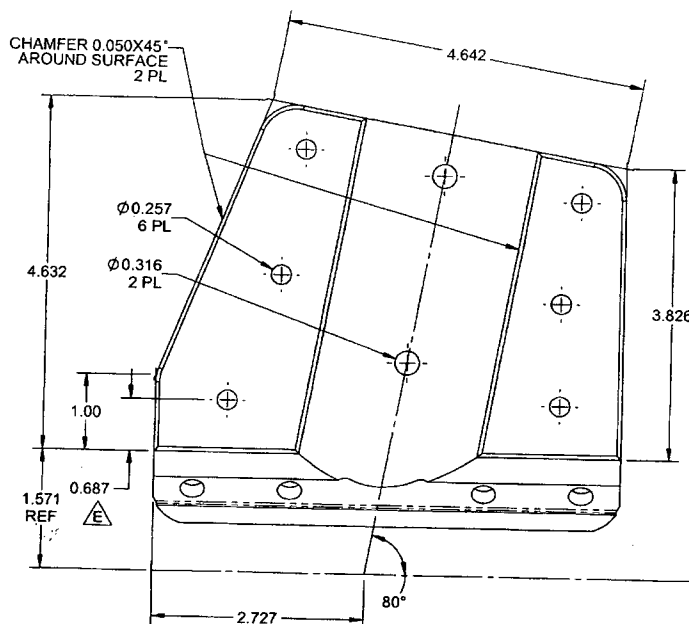
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WORK ORDER
NO. 91225 ML5

12-10-04

RELEASED
2011-11-16

E	REDRAW & REFORMAT DWG: 0.687 WAS 0.547 (B&2, B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	08.11.08
C	INCORP' DEO 9122/9102/9085/9137	CB	08.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	GP		
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D2662	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

91225

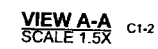


D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



DESIGN	90	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INSIDE COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	REV. E
DRAWN	90		SHEET 3 OF 5
CHECKED	ASB		SCALE
MFG. APPR.	ASB		NTS
APPROVED	WAB		
DE APPR.	#		
DATE 11.10.31			

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WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

CHAMFER 0.050X45°
AROUND SURFACE
2 PL

Ø0.257
6 PL

Ø0.316
2 PL

0.063

R0.50
TYP

A6 S

+0.005
-0.000

0.140
0.100

R1.575

48°

1.615

0.110

0.235 +0.005
-0.000

0.687

E

1.00

4.632

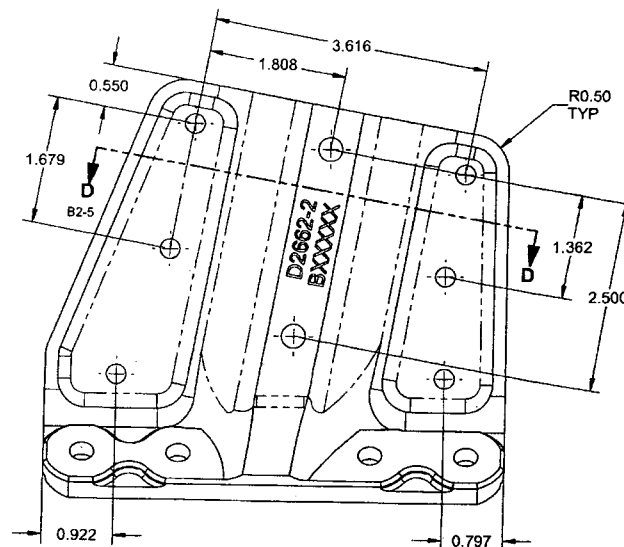
4.642

3.826

1.571
REF

80°

2.727



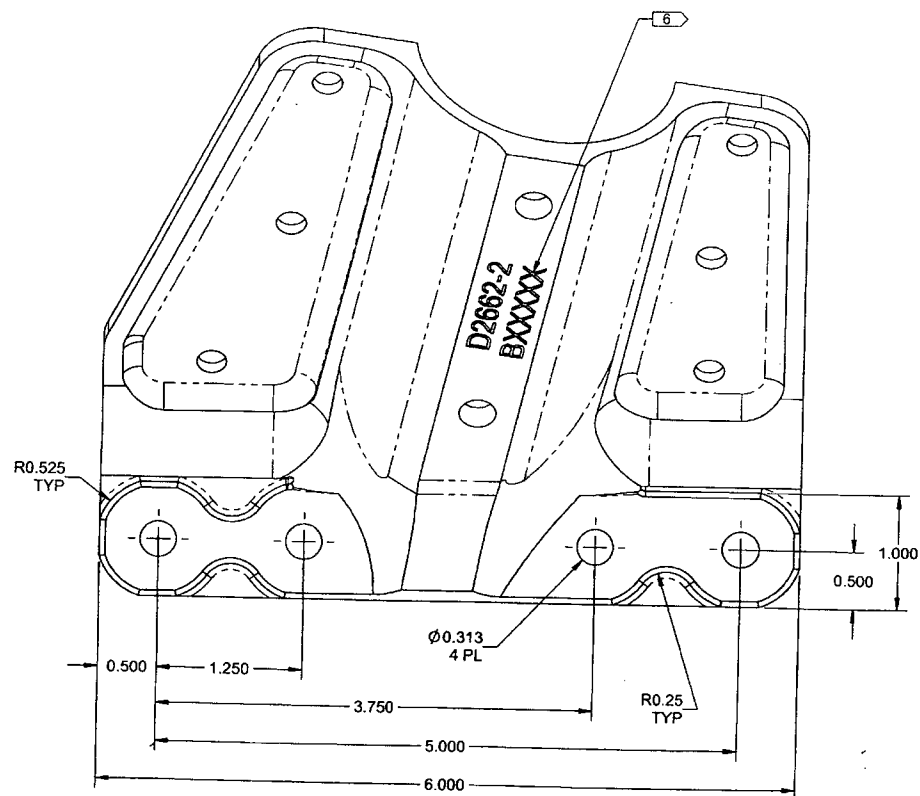
RELEASE
2011-11-16

D2662-2 SADDLE, INSIDE, RH

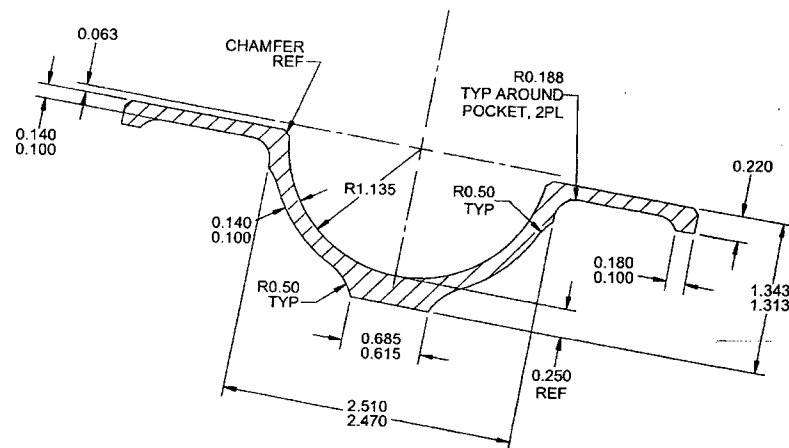
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209 MAKE FROM D8101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN	<i>AS</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INDI SCALE NTST COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPLICIT CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR PARAPHRASED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	REV. E
DRAWN	<i>AS</i>		SHEET 4 OF 4
CHECKED	<i>AS</i>		
MFG. APPR.	<i>AS</i>		
APPROVED	<i>AS</i>		
DE APPR.	<i>AS</i>		
DATE	11.10.31		

91225



VIEW D-D
SCALE 1.5X B4-4
VIEW ROTATED



VIEW C-C
SCALE 1.5X C3-4

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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